

Date: Tuesday, 1/30/2007 10:23:37 AM  
 User: Jeff Luc Menard

## Process Sheet

PRELIMINARY ISSUE

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET  
 Job Number : 30494  
 Estimate Number : 12679  
 P.O. Number :  
 This Issue : 1/30/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : SMALL / MED FAB  
 Previous Run :  
 Written By : *Jeff* 07-01-30  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07-01-30 JLM

Part Number : D35701  
 Drawing Number : D3570 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : U/R  
 Material :  
 Due Date : 2/6/2007 Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S080 0.125" 6061-T6 .080 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total: 0.7455 sf(s)

6061-T6 .080 Sheet 0.125"

Batch: *MT 1029448*

103156

\*\*\*Grain must be Along 4.500\*\*\*\*\*

*MT 07 01 30*

(10)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: *U/R*Prog Rev: *U/R*

2-Deburr if necessary

*MT 07 01 30*

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MT 07 01 30*

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*07-02-07*

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Form as per Dwg D3570

*Jeff*

(6)

Date: Tuesday, 1/30/2007 10:23:37 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30494

Part Number: D35701

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

**ENGINEERING  
APPROVAL**

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PC 07.02.08

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

07/02/08

(6)

8.0

POWDER COATING

POWDER COATING



M 101601



(6x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-R/a.m

07/02/06

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CL 07/02/08

(6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:           

CL 07/02/08 (6)

11.0

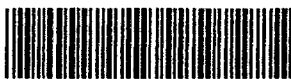
QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CL 07/02/08

DART AEROSPACE LTD		Work Order: 30494
Description: Bracket		Part Number: D3570-1
Inspection Dwg: D3570 Rev: 4/2		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<del>Ø 0.209</del>	<del>+0.005-0.001</del>	<del>0.209</del>	<del>✓</del>		<del>VERN</del>	
<del>Ø 0.323</del>	<del>+0.006-0.001</del>	<del>0.325</del>	<del>✓</del>		<del>VERN</del>	
<del>2.25</del>	<del>+/- 0.030</del>	<del>2.25</del>	<del>✓</del>		<del>VERN</del>	
<del>4.50</del>	<del>+/- 0.030</del>	<del>4.502</del>	<del>✓</del>		<del>VERN</del>	
<del>1.600</del>	<del>+/- 0.010</del>	<del>1.600</del>	<del>✓</del>		<del>VERN</del>	
<del>1.420</del>	<del>+/- 0.010</del>	<del>1.420</del>	<del>✓</del>		<del>VERN</del>	
<del>0.360</del>	<del>+/- 0.010</del>	<del>0.360</del>	<del>✓</del>		<del>VERN</del>	
<del>Ø 3.66</del>	<del>+/- 0.030</del>	<del>3.66</del>	<del>✓</del>		<del>VERN</del>	
Ø 2.09	+0.006 - 0.001	Ø 2.13	✓			
2.25	± 0.03	2.248	✓			
1.420	± 0.01	1.421	✓			
0.42	± 0.03	0.421	✓			
0.36	± 0.03	0.368	✓			
1.600	± 0.01	1.602	✓			
4.63	± 0.03	4.630	✓			
1.00	± 0.03	1.004	✓			

Measured by: M. M	Audited by: [Signature]	Prototype Approval:
Date: 07 01 30	Date: 07	Date:

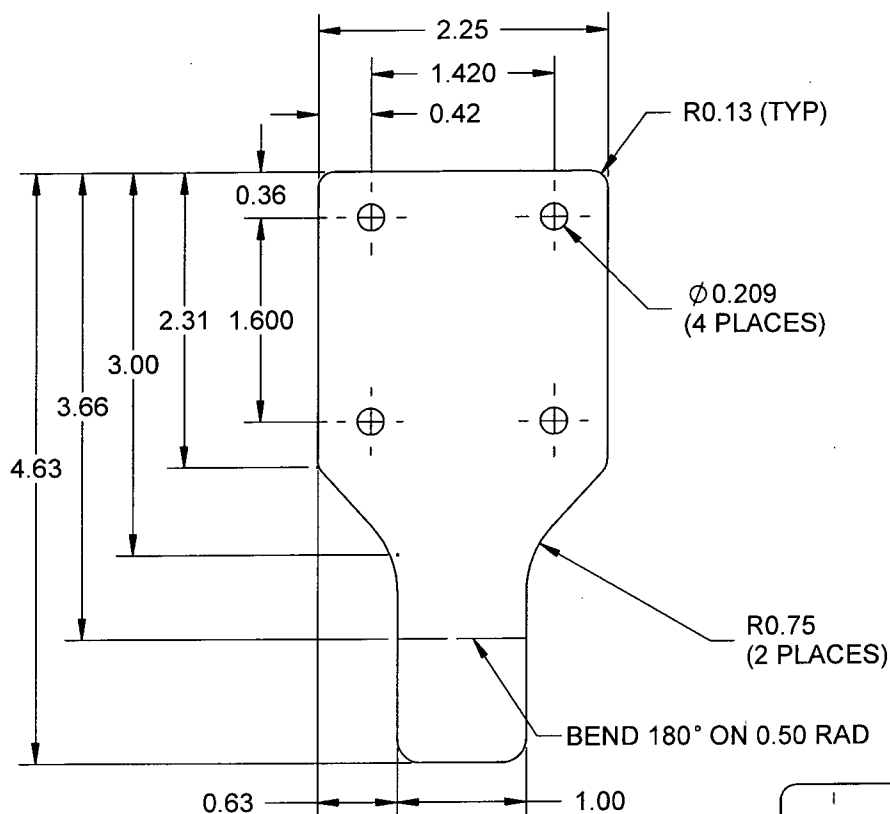
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

PRELIMINARY ISSUE

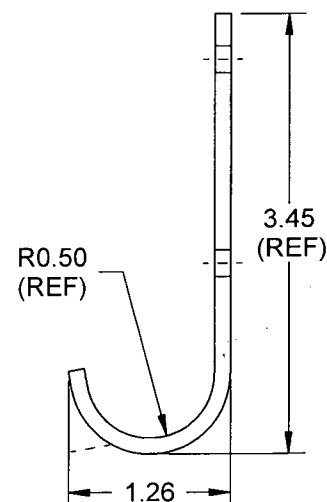
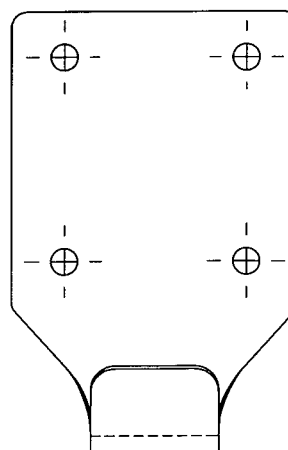
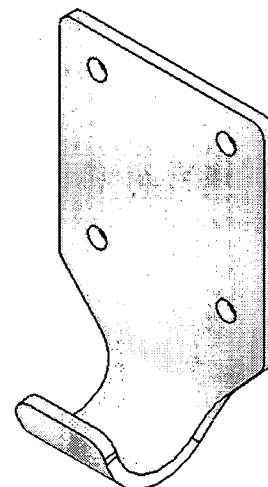
UNDER REVIEW

07.02.07 L6

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED	DRAWING NO. D3570	REV. A SHEET 1 OF 1
DATE 07.02.07	TITLE BRACKET		SCALE 2:3
REV A	DATE 07.02.07	DESCRIPTION NEW ISSUE	



**D3570-1F FLAT PATTERN**



**D3570-1 BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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